

# Work Order ID 72889

Wednesday, August 17, 2011 2:43:52 PM

Page 1

Item ID: D4314-1

Accept

Revision ID:

Item Name: Shim

Start Date: 8/17/2011 Start Qty: 4.00

Required Date: 8/25/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date: 11-0

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4314

A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

6061 .125

1-Cut as per Dwg D4314

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

B11-8-18

68

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-8-18

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Sulzer

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72889

Wednesday, August 17, 2011 2:43:52 PM



Page 2

Item ID: D4314-1

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 8/17/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	COUNTER SINK AS PER DWG								
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
160		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

8/21/08/18 (8)

8/25/08/19

(78)

8x Ø m-11/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72889

Wednesday, August 17, 2011 2:43:52 PM

Page 3

Item ID: D4314-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Shim

Start Date: 8/17/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8 6 11/08/11

SP

8x

11-08-22 SP

11/8/23

ME 11-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 17, 2011 2:43:58 PM

Page 1

Work Order ID: 72889

Parent Item: D4314-1

Parent Item Name: Shim



Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	132.6514	0.019	0.08	.5		



6061-T6 .125 Sheet



3118-18

Location

Loc Qty

Loc Code

MAT021

132.6513684

113608

77.17

116700

0.98136842

118217

54.5

118217

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

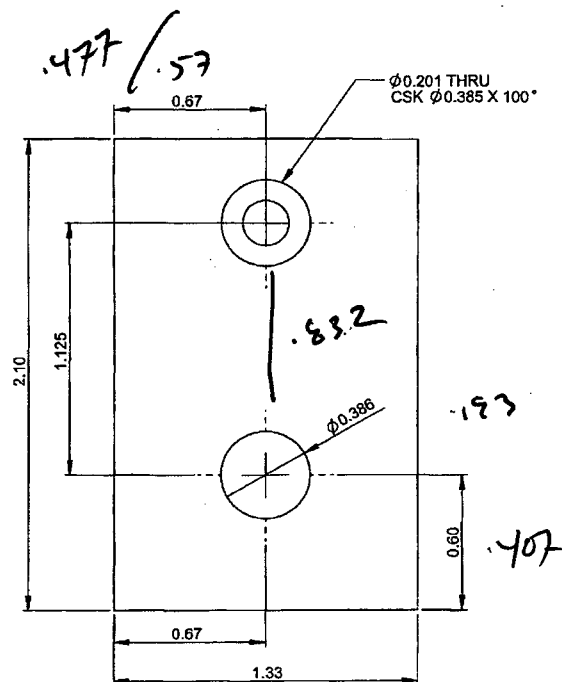
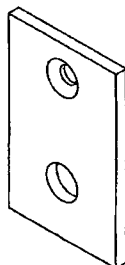
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D4314-1 SHIM**

**NOTES:**

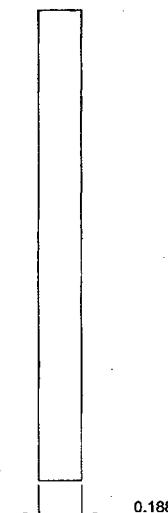
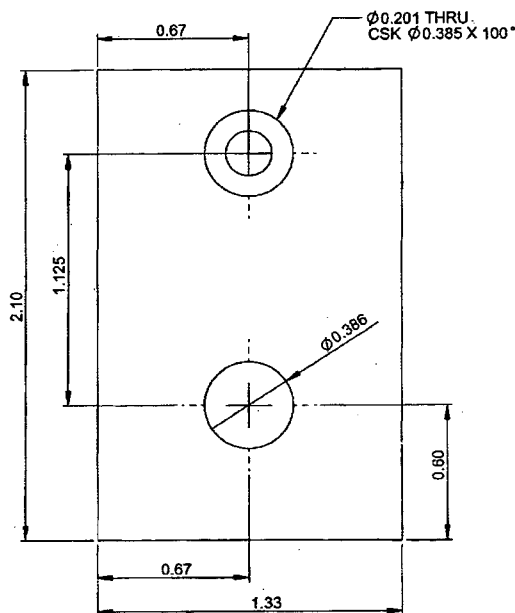
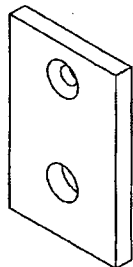
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

SHOP COPY  
REF ID: Q  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO APPROVAL  
WITHOUT A  
WORK ORDER  
NO. 72889

*RL-08-17*

**RELEASED**  
2011-02-13  
*MB*

A NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION		BY DATE
DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4314</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>SHIM</b>	NTS
DATE 11.01.13		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



72889

D4314-3 SHIM

RELEASED  
2011-02-01  
MP

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.188) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.188)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	MP	D4314	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SHIM	NTS
DATE	11.01.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	